

Date: Friday, 13/06/2008 1:48:46 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR PANEL
Job Number : 39874	
Estimate Number : 11401	
P.O. Number :	Part Number : D32961
This Issue : 13/06/2008 S.O. No. :	Drawing Number : D3296 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 39744	Material :
Written By :	Due Date : 23/06/2008 Qty: 12 Um: Each
Checked & Approved By : <u>JUL 08.6.13</u>	
Comment : Est C 05.10.14 Added step 14 KJ/EC Est Rev:D Now on Waterjet 06-11-02 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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9.2



Comment: Qty.: 0.6926 sf(s)/Unit Total : 8.3110 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063) 106003X3=255
 Identify for D3296-1 103301X1=1
 Batch: 104921X8=6 HB 8-6-16

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3296
 Dwg Rev: A
 Prog Rev: A

HB 8-6-16

(12)

2-Deburr if necessary HB 8-6-16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB 8-6-16

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

S 08/06/16 412

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

n/a Done at step 22.2
 08/06/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/06/2008 1:48:46 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR PANEL

Job Number: 39874

Part Number: D32961

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



12X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. 08/06/17

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



12

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F. 08/06/17

8.0

PACKAGING 1

PACKAGING RESOURCE #1



10X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 180

8/6/17

SG

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/17

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 08.06.18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

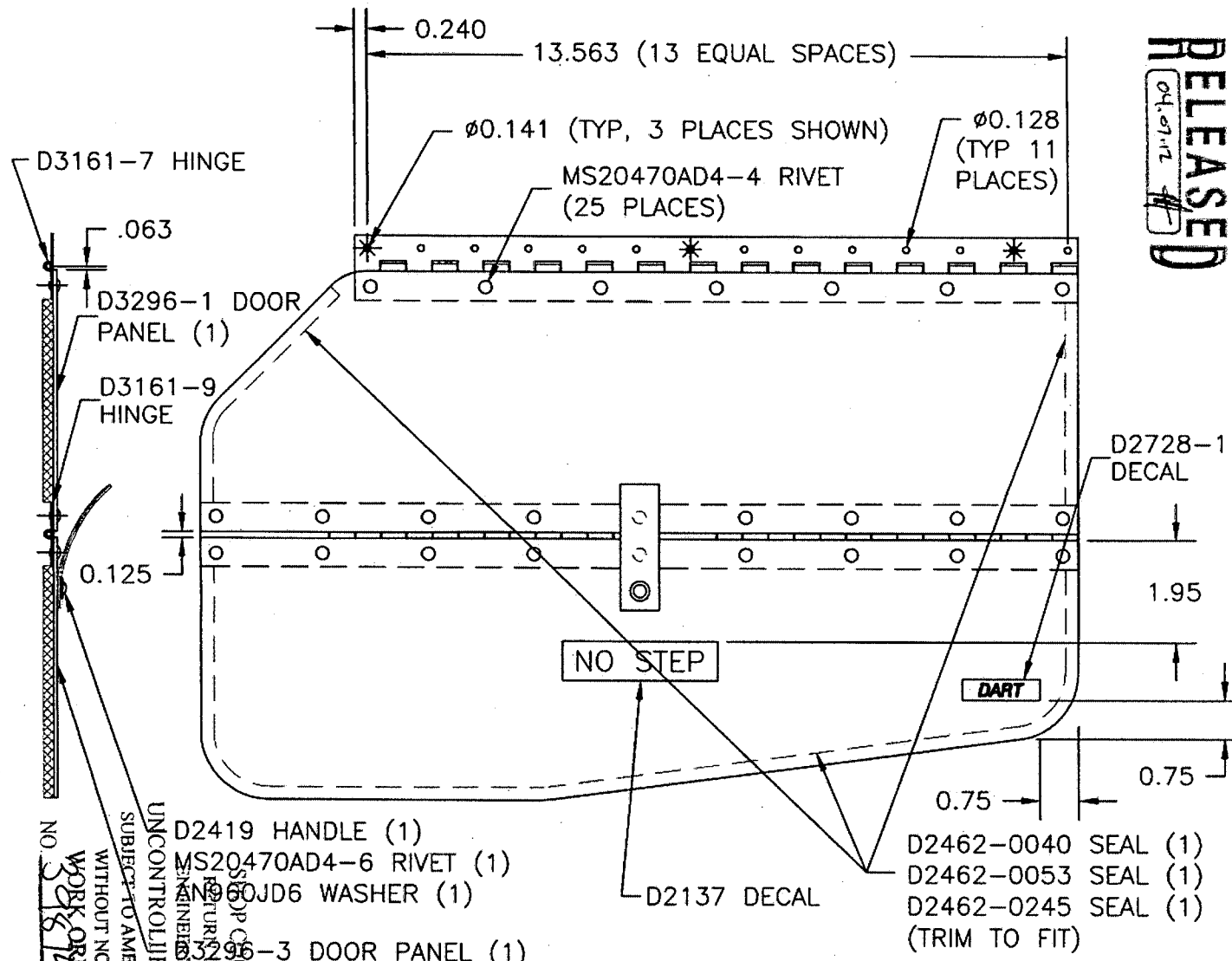
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
04.07.12

DESIGN	DRAWN BY	DART AEROSPACE LTD
04.06.28	04.06.28	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
04.06.28	04.06.28	D3296
DATE	TITLE	REV. A
04.06.28	DOOR ASSEMBLY	1 OF 2
A	NEW ISSUE	SCALE
		1:3

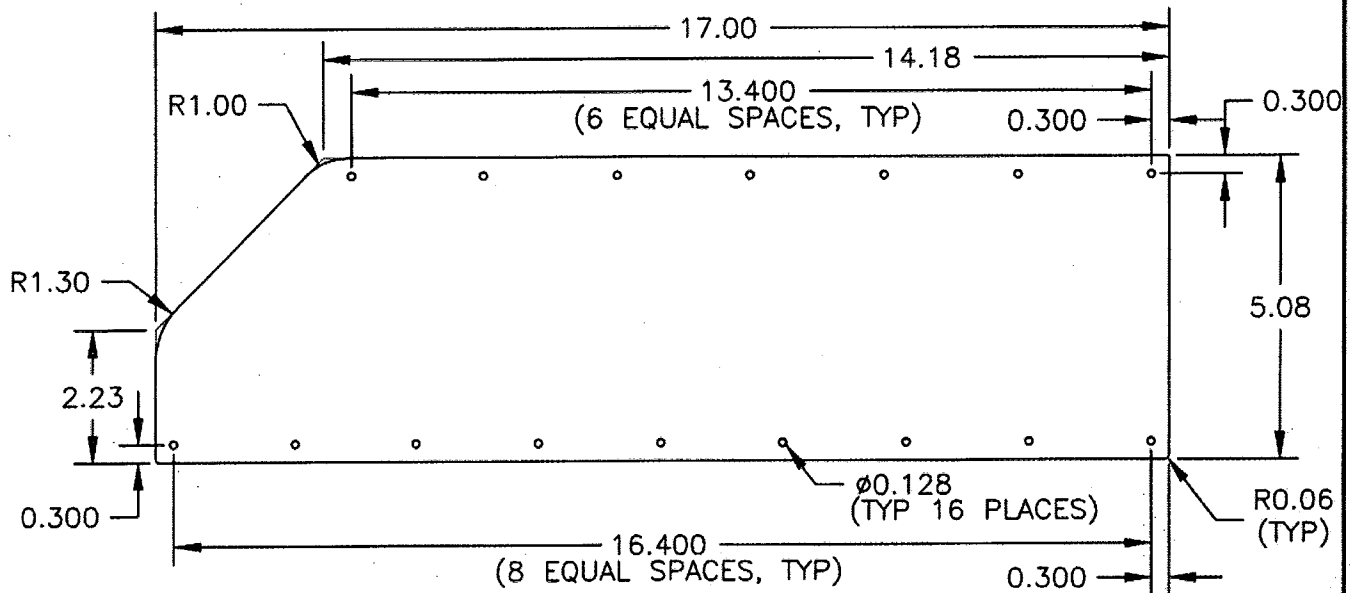


D3296-4 DOOR ASSEMBLY

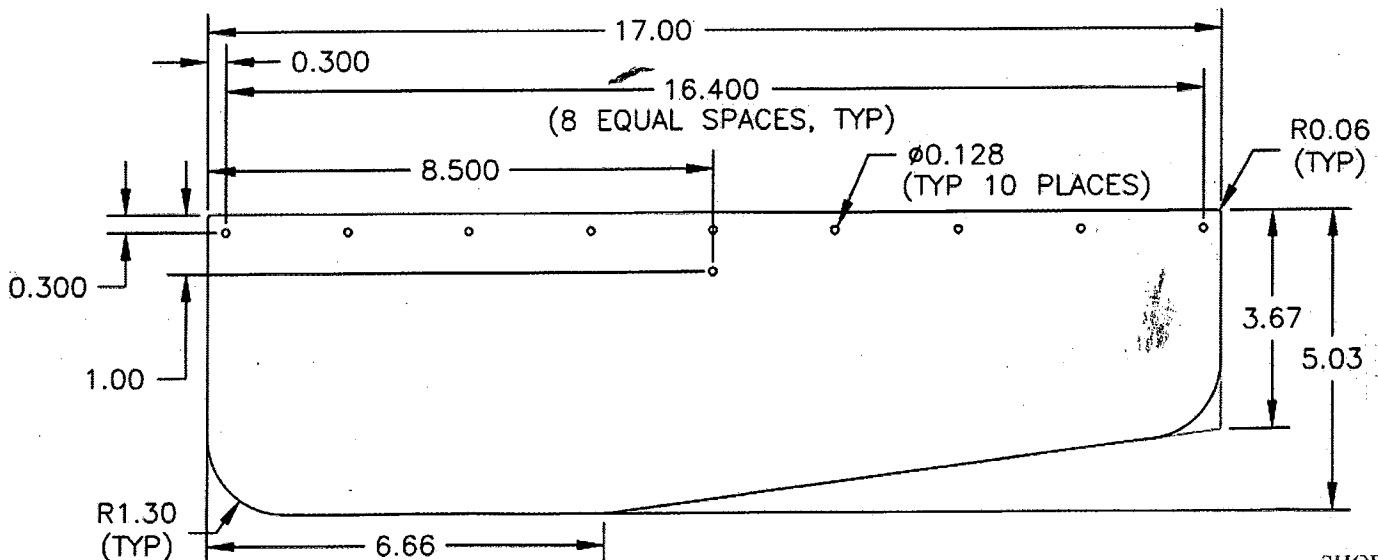
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 39874

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